

CLAIMS

1. A method of assembling steering columns,
comprising the steps of:

5 forming a cylindrical column jacket;
forming a pair of joint projections
comprising inner surfaces in a circular arc shape
conforming to an outer surface of said column
jacket on a bracket;

10 temporary fitting said projections of said
bracket along the outer surface of said column
jacket; and

crimping said projections into the outer
surface of said column jacket.

15 2. A method of assembling steering columns,
comprising the steps of:

forming a cylindrical column jacket;
forming a pair of flat surfaces back to back
20 on an outer surface of said cylindrical column
jacket;

forming a pair of joint projections
comprising flat inner surfaces conforming to the
pair of flat surfaces of said column jacket on a
25 bracket;

temporary fitting said projections of said
bracket along the flat surface of said column
jacket; and

crimping said projections into the flat surface of said column

3. A method of assembling steering columns according to claim 1 or claim 2, wherein in forming said a pair of joint projections, said projections are symmetrically formed with respect to the center of said bracket.

10 4. A method of assembling steering columns according to claim 1 or claim 2, wherein in crimping said projections, these are crimped with a punch which is pressed toward the center of said column jacket.

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5. A method of assembling steering columns according to claim 1 or claim 2, wherein in forming said column jacket, a cylindrical column jacket is formed from a mild steel tube.

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6. A method of assembling steering columns according to claim 1 or claim 2, wherein in forming said column jacket, a cylindrical column jacket is formed from an Al-Mn alloy tube.